












Date: Tuesday, 22/07/2008 11:27:07 AM  
 User: Julie Lecocq

## Process Sheet

|  |   |   |              |
|--|---|---|--------------|
| <b>Customer</b>  | : CU-DAR001 Dart Helicopters Services   | <b>Drawing Name</b>   | : REAR RAIL  |
| <b>Job Number</b>  | : 40710   |   |              |
| <b>Estimate Number</b>   | : 13494   |   |              |
| <b>P.O. Number</b>   | :   | <b>Part Number</b>  | : D37663     |
| <b>This Issue</b>  | : 22/07/2008  | <b>S.O. No.</b>   | :            |
| <b>Prsht Rev.</b>  | : NC  | <b>Drawing Number</b>   | : D3766 REVB |
| <b>First Issue</b>   | : / /   | <b>Project Number</b>   | : N/A        |
| <b>Previous Run</b>  | :   | <b>Drawing Revision</b>   | : B          |
| <b>Written By</b>  | :   | <b>Material</b>   | :            |
| <b>Checked &amp; Approved By</b>   | : <u>JUL 08.7.22</u>  | <b>Due Date</b>   | : 10/08/2008 |
| <b>Comment</b>   | : Est Rev:A 08-07-21 revB as per dwg DD verified by:EC                              |   |              |
| <b>Additional Product</b>  |   |   |              |
| Job Number:   |   |   |              |
| <b>Seq. #:</b>   | <b>Machine Or Operation:</b>  | <b>Description :</b>  |              |
| 1.0  | M6061T6T1000W188  | 6061T6 RD TUBE 1.00 X .188W   |              |
|  |    |    |              |
| <b>Comment:</b> Qty.: 2.9323 f(s)/Unit Total : 11.7293 f(s)<br>6061T6 RD TUBE 1.00 X .188W<br>batch: <u>M1044802x1 / M104779x3</u> <u>FF 08-07-23</u> (4)  |   |   |              |
| 2.0  | SMALL FAB 1   | SMALL & MEDIUM FAB RESOURCE 1   |              |
|  |  |  |              |
| <b>Comment:</b> SMALL & MEDIUM FAB RESOURCE 1<br>1-cut tube to length as per dwg D3766 <u>FF 08-07-23</u> (4)<br>2-drill holes thru to finish size as per dwg D3766 <u>FF 08-08-08</u> (4)<br>3- deburr <u>FF 08-08-11</u> (4) |   |   |              |
| 3.0  | QC5   | INSPECT WORK TO CURRENT STEP  |              |
|  |  |  |              |
| <b>Comment:</b> INSPECT WORK TO CURRENT STEP <u>508/08/11</u> (4)  |   |   |              |
| 4.0  | HAND FINISHING1   | HAND FINISHING RESOURCE #1  |              |
|  |  |  |              |
| <b>Comment:</b> HAND FINISHING RESOURCE #1<br>Chemical Conversion Coat as per QSI 005 4.1 <u>08-08-11</u>  |   |   |              |
| 5.0  | QC3   | INSPECT POWDER COAT/CHEMICAL CONVERSION   |              |
|  |  |  |              |
| <b>Comment:</b> INSPECT POWDER COAT/CHEMICAL CONVERSION <u>08-08-11</u> (4)  |   |   |              |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Tuesday, 22/07/2008 11:27:07 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: REAR RAIL

Job Number: 40710

Part Number: D37663

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



(4x)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 313

8/8/11

SP

7.0

QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

2008/08/12

Job Completion



MF 08-08-11

**Dart Aerospace Ltd**

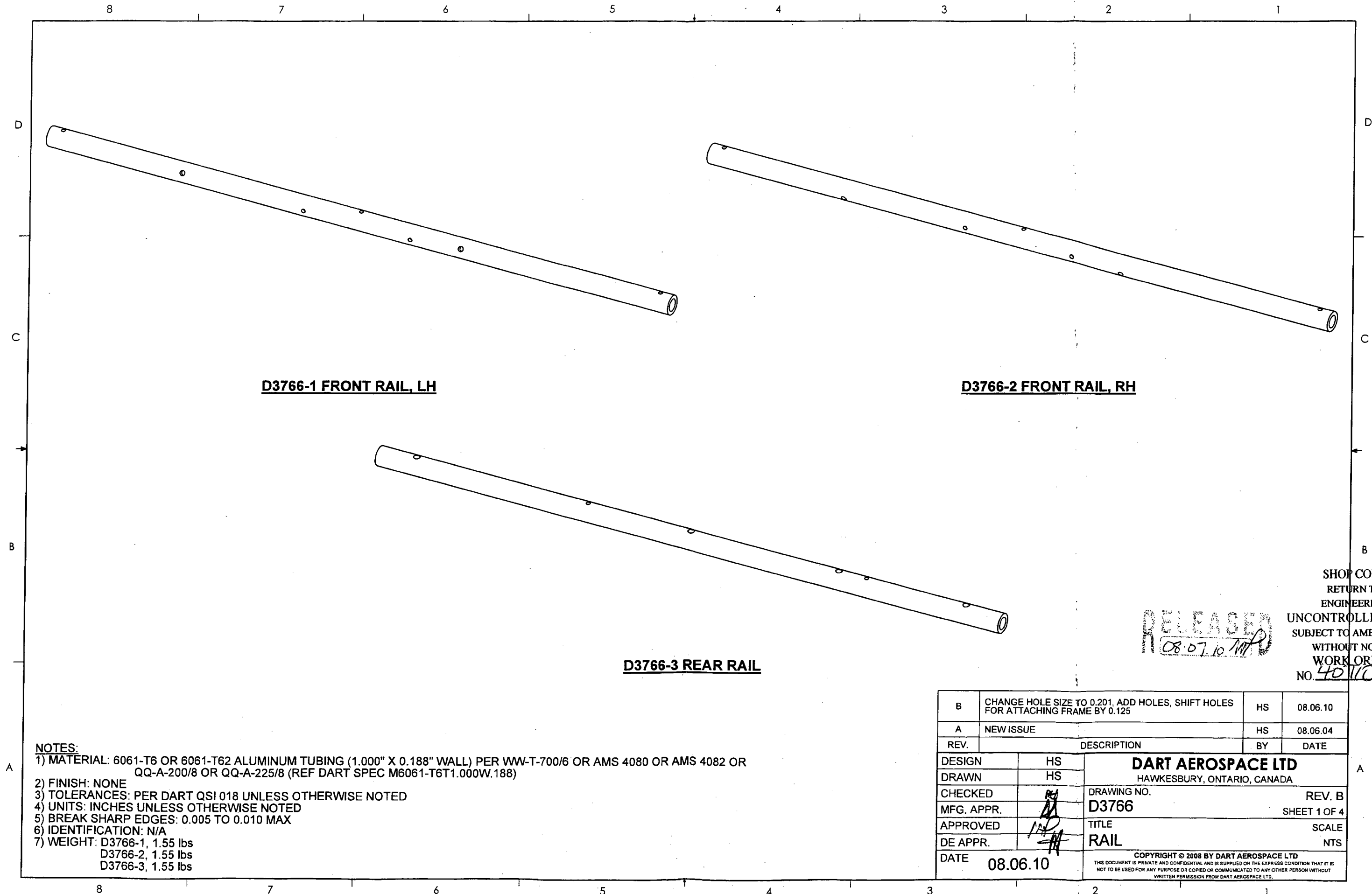
| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



**D3766-1 FRONT RAIL, LH**

**D3766-2 FRONT RAIL, RH**

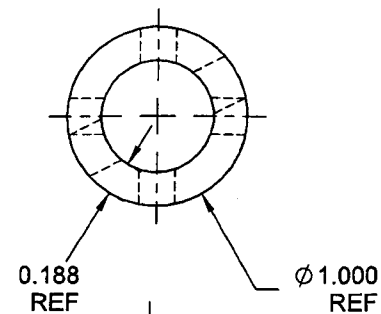
**D3766-3 REAR RAIL**

**NOTES:**

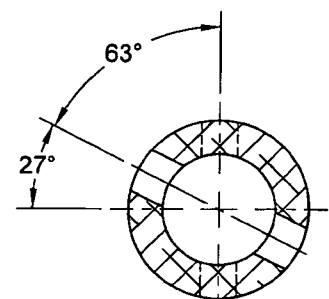
- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.000" X 0.188" WALL) PER VVV-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF DART SPEC M6061-T6T1.000W.188)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3766-1, 1.55 lbs  
D3766-2, 1.55 lbs  
D3766-3, 1.55 lbs

|            |  |  |              |
|------------|--|--|--------------|
| B          | CHANGE HOLE SIZE TO 0.201. ADD HOLES, SHIFT HOLES FOR ATTACHING FRAME BY 0.125 | HS   | 08.06.10     |
| A          | NEW ISSUE  | HS   | 08.06.04     |
| REV.       | DESCRIPTION  | BY   | DATE         |
| DESIGN     | HS   | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA   |              |
| DRAWN      | HS   |  |              |
| CHECKED    | <i>[Signature]</i>   | DRAWING NO.  | REV. B       |
| MFG. APPR. | <i>[Signature]</i>   | <b>D3766</b>   | SHEET 1 OF 4 |
| APPROVED   | <i>[Signature]</i>   | TITLE  | SCALE        |
| DE APPR.   | <i>[Signature]</i>   | <b>RAIL</b>  | NTS          |
| DATE       | 08.06.10   | COPYRIGHT © 2008 BY DART AEROSPACE LTD<br>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. |              |

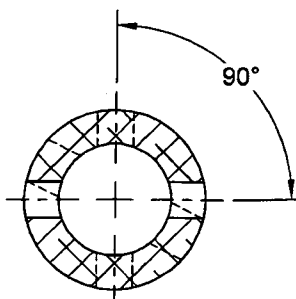
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 40110



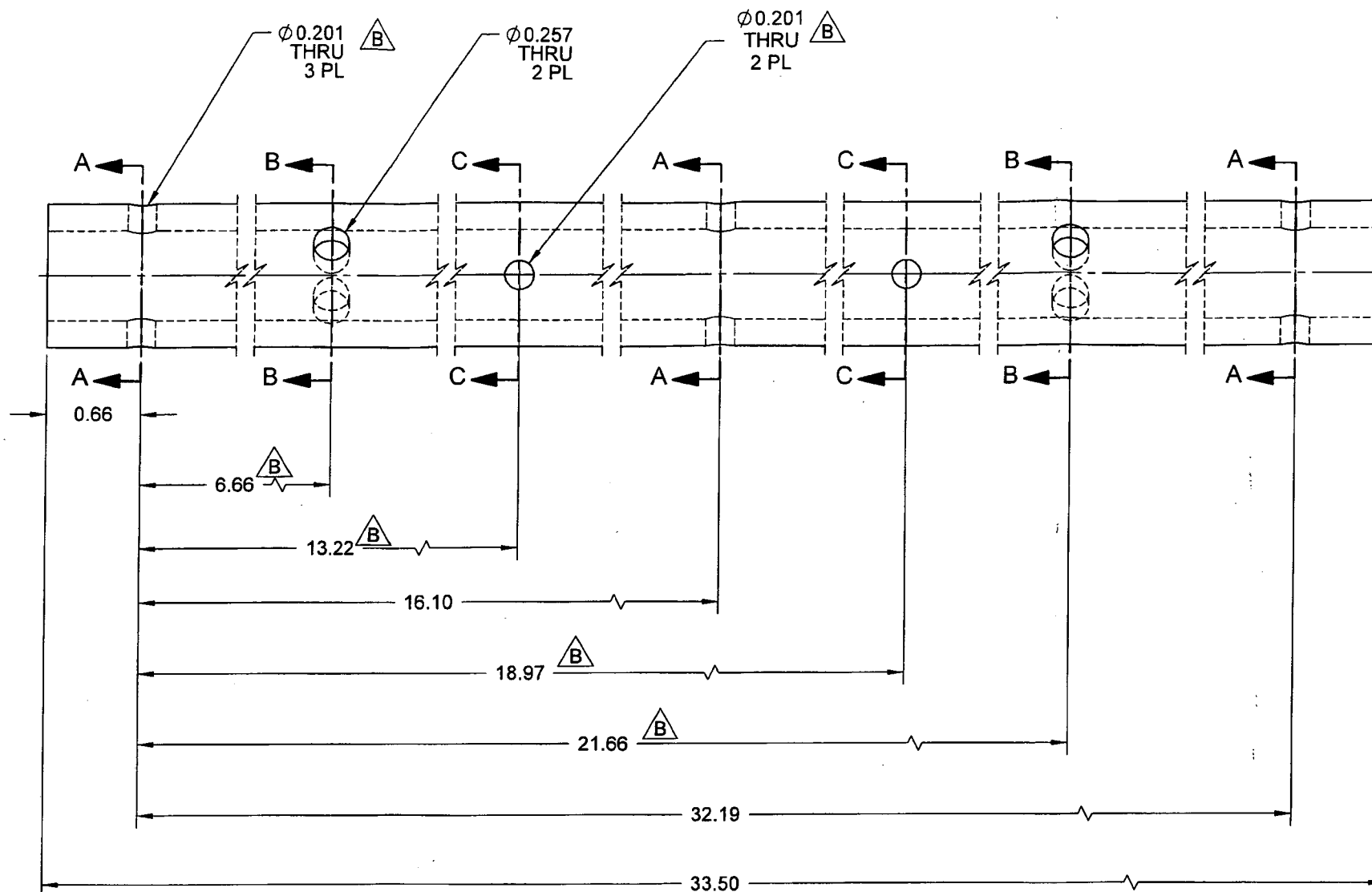
**SECTION A-A**



**SECTION B-B**







**SECTION C-C**

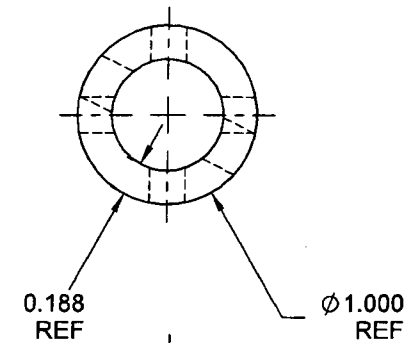


**D3766-1 FRONT RAIL, LH**

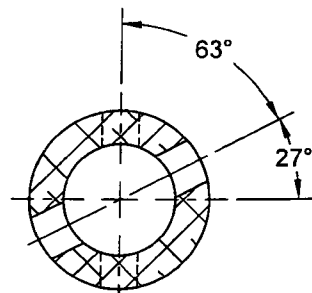
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 40710

RELEASED  
08-07-10/11/12

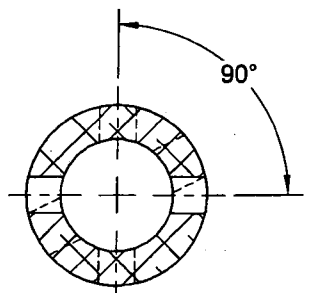
|  |   |  |            |
|--|---|--|------------|
| DESIGN   | HS  | <b>DART AEROSPACE LTD</b>              |            |
| DRAWN  | HS  | HAWKESBURY, ONTARIO, CANADA            |            |
| CHECKED  |  | DRAWING NO.                            | REV.       |
| MFG. APPR.   |  | D3766                                  | SHEET 2 OF |
| APPROVED   |  | TITLE                                  | SCALE      |
| DE APPR.   |  | RAIL                                   | NT         |
| DATE   | 08.06.10  | COPYRIGHT © 2008 BY DART AEROSPACE LTD |            |
| THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. |   |  |            |



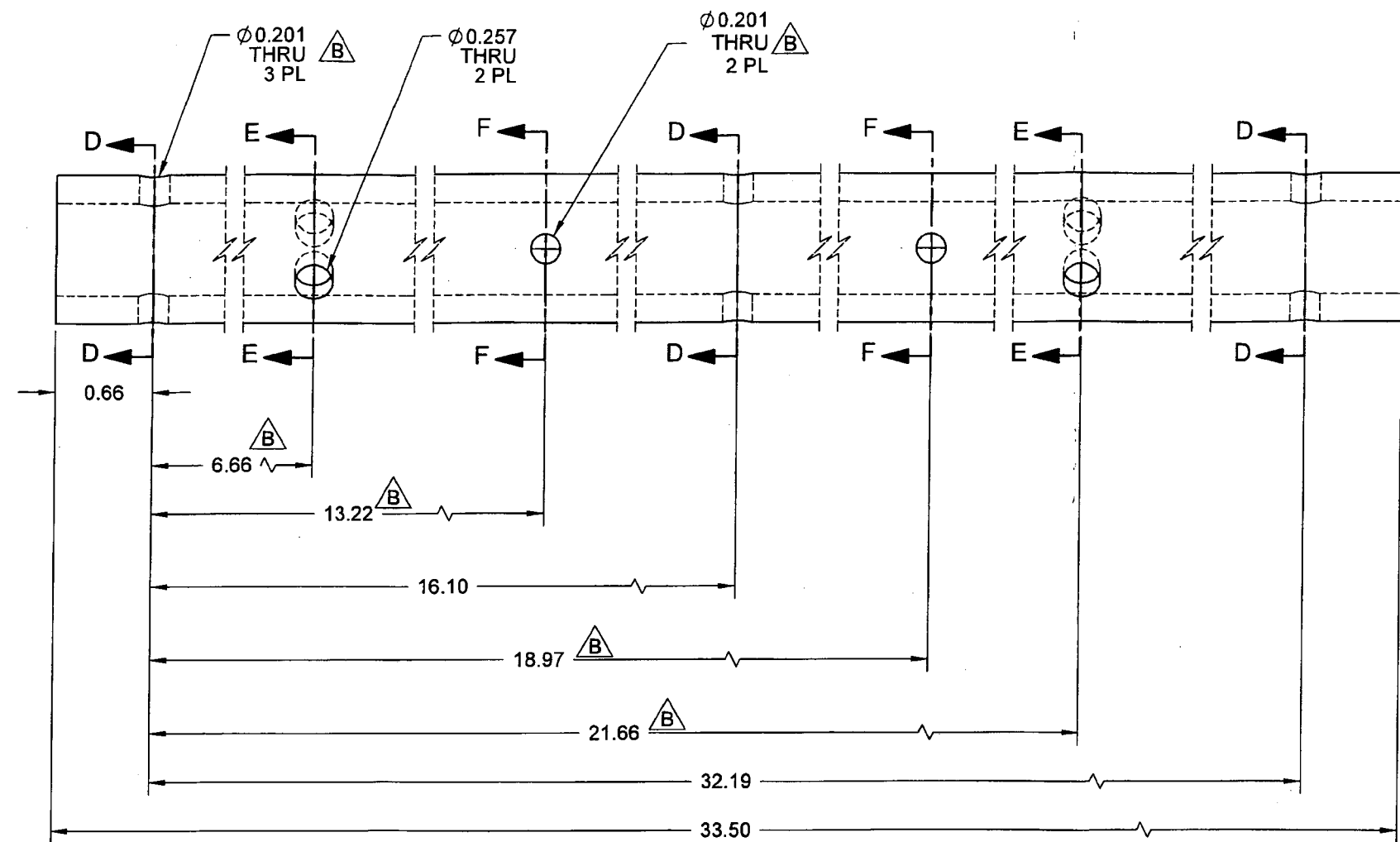
**SECTION D-D**



**SECTION E-E**







**SECTION F-F**



**D3766-2 FRONT RAIL, RH**

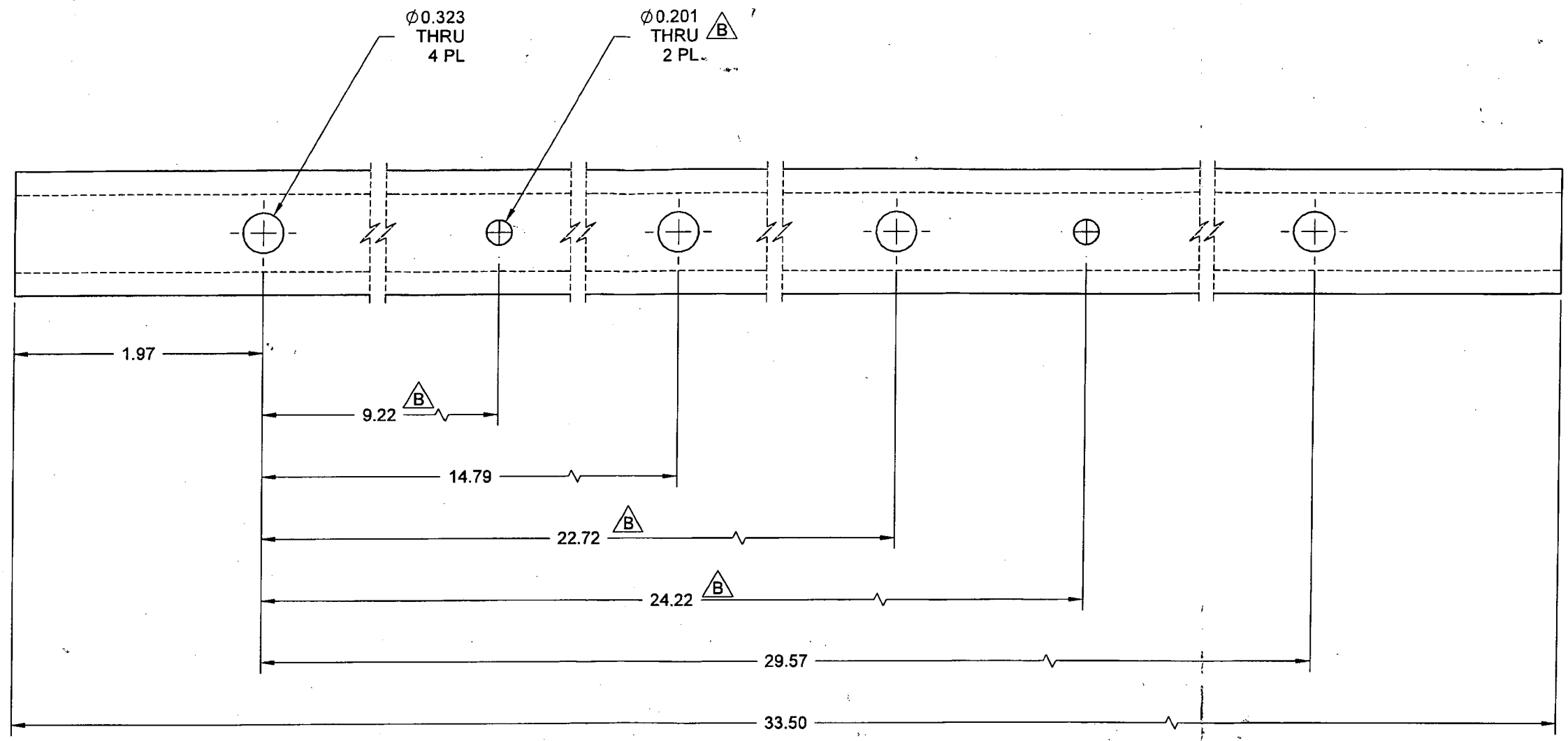
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 40710

RELEASED  
08-07-10

|  |   |  |              |
|--|---|--|--------------|
| DESIGN   | HS  | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |              |
| DRAWN  | HS  |  |              |
| CHECKED  |  | DRAWING NO.  | REV. B       |
| MFG. APPR.   |  | D3766  | SHEET 3 OF 4 |
| APPROVED   |  | TITLE  | SCALE        |
| DE APPR.   |  | RAIL   | NTS          |
| DATE   | 08.06.10  | COPYRIGHT © 2008 BY DART AEROSPACE LTD                   |              |
| THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. |   |  |              |

0.188  
REF

Ø1.000  
REF



**D3766-3 REAR RAIL**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 4070

|            |                    |  |              |
|------------|--------------------|--|--------------|
| DESIGN     | HS                 | <b>DART AEROSPACE LTD</b>  |              |
| DRAWN      | HS                 | HAWKESBURY, ONTARIO, CANADA  |              |
| CHECKED    | <i>[Signature]</i> | DRAWING NO.  | REV. B       |
| MFG. APPR. | <i>[Signature]</i> | <b>D3766</b>   | SHEET 4 OF 4 |
| APPROVED   | <i>[Signature]</i> | TITLE  | SCALE        |
| DE APPR.   | <i>[Signature]</i> | <b>RAIL</b>  | NTS          |
| DATE       | <b>08.06.10</b>    | <small>COPYRIGHT © 2008 BY DART AEROSPACE LTD<br/>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS<br/>NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT<br/>WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> |              |